

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014840**Date Inspected:** 09-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Lift 7 East (7AE, 7CE, 7DE and 7EE ) Corner Assembly Cope Hole

This QA Inspector performed Dimensional Control Inspection for the Corner Assembly Cope Holes Segment 7AE, 7BE, 7CE, 7DE and 7EE for confirming the repair work.

The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Lift 7 West (7AW, 7BW, 7CW, 7DW and 7EW ) Corner Assembly Cope Hole

This QA Inspector performed Dimensional Control Inspection for the Corner Assembly Cope Holes Segment 7AW, 7BW, 7CW, 7DW and 7EW for confirming the repair work.

The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader

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and Engineer for review.

Lift 8 East (8AE, 8BE and 8CE ) Corner Assembly Cope Hole

This QA Inspector performed Dimensional Control Inspection for the Corner Assembly Cope Holes Segment 8AE, 8BE and 8CE for confirming the repair work.

The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Lift 8 West (8AW, 8BW and 8CW) Corner Assembly Cope Hole

This QA Inspector performed Dimensional Control Inspection for the Corner Assembly Cope Holes Segment 8AW, 8BW and 8CW for confirming the repair work.

The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 9CE (Cope Holes)

This QA Inspector performed Dimension Control Inspection after repair for the Floor Beam to Bottom Panel Cope Holes at Work Point (E4) from West Side at Panel Point (PP) 79 for Segment 9CE the Inspection was performed against the ABF Inspection Report No. CWAHIR-9CE-01 Dated April 12, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 10BW (Cope Holes)

This QA Inspector performed Dimension Control Inspection after repair for the Floor Beam to Bottom Panel Cope Holes at Work Point (W4) from West Side at Panel Point (PP) 89 and PP 90 for Segment 10BW the Inspection was performed against the ABF Inspection Report No. CWAHIR-10BW-01 Dated June 03, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 11AW (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection after Heat Straightening the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 96 towards PP 97 from 1920mm to 3200mm Cross Beam Side. The measured readings were recorded on Dimension Control Plan form (DCP) and submitted to the Lead and Engineer for review.

Segment 11AW (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection after Heat Straightening the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 96 towards PP 97 from 930mm to 3500mm

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Counter Weight Side. The measured readings were recorded on Dimension Control Plan form (DCP) and submitted to the Lead and Engineer for review.

Segment 8AE to 8BE (Skin Flatness)

This QA Inspector performed Joint Inspection with ABF Survey Team for the Skin Flatness between Segment 8AE to 8BE (Shop Segment Splice) between Panel Point (PP) 64 and PP 65.

North (Cross Beam side at B1 and B2 locations) at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

The measured readings were recorded on spread sheet, generated the report and submitted to the Lead and Engineer for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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